

**Listing of the Claims:**

Claims 1-3. (Cancelled).

4. (Withdrawn) The apparatus of claim [[1]] 58 wherein the first rotary die further comprises a first end surface and an opposite second end surface, the first die having a radially raised flange adjacent to the first and the second end surfaces.

5. (Withdrawn) The apparatus of claim 4 wherein each of the raised flanges defines a shoulder operably engageable with the corresponding rollers of the first bearing and the second bearing of the first modular die support to limit linear longitudinal translation of the first die along the first axis of rotation.

6. (Withdrawn) The apparatus of claim 5 wherein each of the raised flanges defines a shoulder operably engageable with a corresponding end of the second die to limit linear longitudinal translation of the second die along the second axis of rotation.

Claims 7-11. (Cancelled)

12. (Withdrawn) A rotary die apparatus comprising:

a frame having a base, a plurality of elongate circular columns having a first end and a second end defining a first axis of movement along a length thereof, the first ends of the columns removably mounted with respect to the base and the second ends of the columns removably mounted with respect to a cover, at least one cross member, the cross member movably engagable with respect to at least two of the plurality of circular columns for movement along the first axis;

a first rotary die having a first axis of rotation, the first die having a first end surface and an opposite second end surface, and a raised radial flange adjacent the first and second end surfaces;

a second rotary die having a second axis of rotation positioned in substantially parallel alignment with the first axis of rotation and rollingly engaged with the first die, the second die having a first end surface and an opposite second end surface positioned axially inward of the radial flanges and operably engaged with the radial flange of the first die to limit linear translation of the second die along the second axis of rotation, the cross member positioned transverse to the second rotary die having the second axis of rotation;

a first modular die support removably mounted directly to the base in a location spaced from the columns, the first die support having a first bearing member and a second bearing member, the second bearing member separated from the first bearing member along the first axis of rotation, the first and second bearing members each having at least two rollers each roller having an axis of rotation substantially

parallel to one another and angularly spaced from one another with respect to the first axis of rotation providing exclusive support vertically and horizontally transverse to the first axis of rotation through rolling engagement with the first rotary die, at least one of the first and second bearing members operably engaged with the raised radial flange to limit movement of the first rotary die longitudinally along the first axis of rotation; and

a second modular die support removably mounted directly to the cross member in a location spaced from the columns, the second die support having a first bearing and a second bearing member, the second bearing member separated from the first bearing member along the second axis of rotation, the first and second bearing members each having at least two rollers in exclusive rolling vertical downwardly pressing engagement with the second rotary die, each roller having an axis of rotation substantially parallel to one another and angularly spaced from one another with respect to the second axis of rotation.

13. (Previously Presented) An improved rotary die apparatus having a first rotary die with a first axis of rotation and a second rotary die with a second axis of rotation, the second axis of rotation parallel to the first axis of rotation, the apparatus having a frame including a base, a cover opposite the base, a pair of opposing cross members positioned transverse to the first and second axis of rotation, the cross members moveable between the base and the cover, and a pressure member operably engaged with the cover and the cross members, the improvement comprising:

the frame having a low speed mode of operation below 600 linear feet per minute, the frame further including:

four elongate columns, each column having a first end and a second end, the first end of each column mounted to the base such that the columns are positioned parallel and spaced from one another, and the second end of each column mounted to the cover, each column defining a vertically extending length, the columns having a uniform cross section along the length between the base and the cover;

a die support kit operably engagable with the frame, the die support kit for low speed mode of operation consisting of a first modular die support and a second modular die support, the first modular die support having a first bearing and a second bearing positioned spaced from one another with respect to the first axis of rotation, each bearing mounted directly on the base in a location spaced from the columns, each bearing having at least two rollers, each roller having an axis of rotation substantially parallel to one another and angularly spaced from one another with respect to the first axis of rotation, the rollers in rolling engagement and maintaining the first rotary die in a stationary rotary position upwardly, horizontally transverse to the first axis of rotation and longitudinally along the first axis of rotation with respect to the base, the rollers in operable engagement with a raised radial flange on each of a first and a second end of the first rotary die to limit linear translation of the first rotary die along the first axis of rotation, and the second modular die support having a first bearing and a second bearing positioned spaced from one another with respect to the second axis of rotation, each

bearing mounted to one of the cross members spaced from the columns in rolling engagement with the second rotary die.

14. (Cancelled)

15. (Previously Presented) The apparatus of claim 13 wherein the second die further comprises a first end and an opposite second end positioned axially inward of the raised radial flanges, each of the first and the second ends operably engagable with the adjacent radial flange of the first die to limit linear translation of the second die along the second axis of rotation.

16. (Previously Presented) The apparatus of claim 13 wherein the first and second bearing of the second modular die support comprise at least two rollers, each roller having an axis of rotation substantially parallel to one another and angularly spaced from one another with respect to the second axis of rotation, the first and the second bearings in rolling engagement with and maintaining the second rotary die in a stationary rotary position in a horizontal direction transverse to the second axis of rotation.

Claims 17-39. (Cancelled)

40. (Withdrawn) A rotary die module for use with a first rotary die having a first axis of rotation and a second opposing rotary die having a second axis of rotation, the rotary die module comprising:

a base;

four parallel elongate rods having a first end and a second end defining a first axis of movement along a length thereof, the first ends of the rods mounted to the base, the rods spaced with respect to one another defining two pair of opposing rods with one pair of rods adjacent each end of the base, the second ends of the rods mounted to a cover, the rods having a uniform cross section along the length between the cover and the base;

a pair of opposing cross members, each cross member positioned on one pair of rods and extending transverse to the first and second axis of rotation, each cross member movably engaged on the rods for movement along the first axis of movement;

a first modular die support having a first bearing and a second bearing, the second bearing positioned spaced from the first bearing with respect to the first axis of rotation, each bearing having at least two rollers, each roller having an axis of rotation substantially parallel to one another and angularly spaced from one another with respect to the first axis of rotation, each bearing attached directly to the base spaced from the columns, the first die support providing exclusive support vertically, horizontally transverse to the first axis of rotation and longitudinally along the first axis of rotation through engagement with the first rotary die, the rollers of at least one of the first and

second bearings operably engaging a shoulder defined by a raised radial flange on the first rotary die to limit linear longitudinal translation of the first rotary die along the first axis of rotation;

a second modular die support having a first bearing and a second bearing, the second bearing positioned spaced from the first bearing with respect to the second axis of rotation, each bearing having at least two rollers, each roller having an axis of rotation substantially parallel to one another and angularly spaced from one another with respect to the second axis of rotation, each bearing directly attached to one of the cross members spaced from the rods to receive and rotatably engage the second rotary die; and

a pressure member engaged with the cover and the cross members for controlling movement of the second modular die support along the first axis of movement.

Claims 41-49. (Cancelled).

50. (Currently Amended) ~~The modular die apparatus of claim 49~~ A modular rotary die apparatus having a first rotary die with a first axis of rotation and a second rotary die with a second axis of rotation parallel to the first axis of rotation comprising:

a frame having a low speed mode of operation below 600 linear feet per minute, the frame including:

a base;

a plurality of independent elongate columns, each column having a first end and second end defining a path of travel along a length thereof, the first end of each column mounted to the base in spaced relation to one another;

a cross member engaged with at least two of the plurality of columns for movement of the entire cross member along the path of travel; and

a die support kit operably engagable with the frame, the die support kit for low speed mode of operation including:

a first modular die support for low speed mode of operation below 600 linear feet per minute, the first modular die support mounted to the base spaced from the columns in rolling engagement with the first rotary die, the first modular die support maintaining the first rotary die in a stationary rotary position with respect to the base; and

a second modular die support for low speed mode of operation mounted to the cross member spaced from the columns in rolling engagement with the second rotary die to maintain the second rotary die in a stationary rotary position in a horizontally transverse direction with respect to the second axis of rotation, wherein the each of the first and second modular die supports includes a first bearing assembly and a second bearing assembly positioned in longitudinally spaced locations along the axis of



rotation of the first and the second rotary dies, each of the first and the second bearings having at least two rollers with axes of rotation substantially parallel to one another and each roller angularly spaced from one another with respect to the axis of rotation of the corresponding rotary die, wherein the first rotary die ~~further comprises~~ includes a first end surface and an opposite second end surface, the first rotary die having a radially raised flange adjacent to the first and second end surfaces, the first and the second rollers operably engage the corresponding raised radial flange along the first axis of rotation to limit linear translation of the first rotary die along the first axis of rotation.

51. (Cancelled)

52. (Previously Presented) The modular die apparatus of claim 50 wherein the second rotary die includes a first end and a opposite second end positioned between and operably engaged with the raised radial flanges along the second axis of rotation to limit longitudinal translation of the second rotary die with respect to the first rotary die.

Claims 53-57 (Cancelled).

58. (Previously Presented) A modular rotary die apparatus having a first rotary die with a first axis of rotation and a second rotary die with a second axis of rotation parallel to the first axis of rotation comprising:

a frame having a low speed mode of operation below 600 linear feet per minute, the frame including:

a base;

a plurality of elongate columns having a first end mounted to the base and a second end;

a cross member positioned opposite the base operably engaged with at least two of the columns adjacent the second ends; and

a die support kit operably engagable with the frame, the die support kit for low speed mode of operation including:

a first modular die support mounted to the base spaced from the columns and consisting of a first bearing member and a second bearing member positioned in longitudinally spaced locations along the axis of rotation of the first rotary die, each bearing member including at least two rollers with axes of rotation located in angularly spaced positions with respect to and parallel to the axis of rotation of the first rotary die, the first and second bearing members in rolling engagement with the first rotary die and maintaining the first rotary die in a stationary rotary position with respect to the base through operable engagement of the rollers with raised radial flanges located on opposite longitudinal ends of the first rotary die; and

a second modular die support mounted to the cross member, the second modular die support consisting of a first bearing member and a second bearing member positioned in longitudinally spaced locations along the axis of rotation of the second rotary die, each bearing member including at least two rollers with axes of rotation located in angularly spaced positions with respect to and parallel to the axis of rotation of the second rotary die, the first and second bearing members in rolling engagement with the second rotary die and maintaining the second rotary die in a stationary rotary position with respect to the base through operable engagement of the raised radial flanges on the first rotary die with longitudinal ends of the second rotary die.

59. (Cancelled).